

Work Order ID 142284

142284

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Item ID: D205-633-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH
 Start Date: 3/21/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/24/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: SHA Date: 20160304 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D205-633	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP205-633-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

ML5 16-03-09

DAS
27
9-89

MAR 11 2016

DAS
27
9-89

DAS
28
9-89

MAR 08 2016

DAS
27
9-89

MAR 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Item ID: D205-633-011 Accept *N900040100* Setup Start *NS1*
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 Start Date: 3/21/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/24/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				2			
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-633-011 Location:FG082								16/3/14
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MS MAR 15 2016

MS MAR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Work Order ID: 142284

142284

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/21/2016

Required Date: 3/24/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:F02.07.11Reformat; Removed D3010 RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-14A *AN4-14A* Bolt		Purchased	No			110	Each	565.0000	1	2		DAS 6 9-89	DAS 28 9-89

Location	Loc Qty	Loc Code
FG	5	
122141	5	
over003	500	
M133998	500	
ST344	60	
M133316	15	
M133769	45	

AN4-5A *AN4-5A* BOLT		Purchased	No			110	Each	177.0000	2	4		DAS 6 9-89	DAS 28 9-89
-----------------------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	------------------	-------------------

Location	Loc Qty	Loc Code
CA	55	
m129682	55	
over003	100	
m134039	100	
ST345	22	
m133064	22	

DAS
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DAS
27
9-89

2
4
4

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Work Order ID: 142284

142284

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/21/2016

Required Date: 3/24/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-6A	Purchased	No	110	Each	924.0000	2	4	DAS 6 9-89	DAS 28 9-89
AN4-6A									
BOLT									

Location	Loc Qty	Loc Code
CA	143	
M128403	43	
M130851	100	
ST345	781	
M133363	1	
M133790	780	

AN4-7A	Purchased	No	110	Each	217.0000	2	4	DAS 6 9-89	DAS 28 9-89
AN4-7A									
Bolt									

Location	Loc Qty	Loc Code
ST325	117	
m131320	17	
m133790	100	
ST345	100	
m134249	100	

AN5-14A	Purchased	No	110	Each	34.0000	2	2	DAS 6 9-89	DAS 28 9-89
AN5-14A									
Bolt									

Location	Loc Qty	Loc Code
ST338	34	
m133990	34	

AN5-6A	Purchased	No	110	Each	43.0000	2	2	DAS 6 9-89	DAS 28 9-89
AN5-6A									
Bolt									

Location	Loc Qty	Loc Code
ST339	43	
m133790	43	

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Work Order ID: 142284

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Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/21/2016

Required Date: 3/24/2016

Start Qty: 2.00

Required Qty: 2.00

D2021-101 Manufactured No

110 Each 12.0000 1 2

D2021-101

Eyebolt
DAS
27
9-89

**

DAS
6
28
9-89

Location

Loc Qty

Loc Code

ST001

12

130984

2

141035

10

D2022-101 Manufactured No

110 Each 121.0000 2 4

D2022-101

Spacer

DAS
27
9-89

**

DAS
6
28
9-89

Location

Loc Qty

Loc Code

ST001

75

132703

75

ST012a

46

140201

46

D2022-103 Manufactured No

110 Each 22.0000 2 4

D2022-103

Spacer

DAS
27
9-89

**

DAS
6
28
9-89

Location

Loc Qty

Loc Code

ST001

22

139455

22

D2562-001 Manufactured No

110 Each 1.0000 0 2

D2562-001

Strut 19.68"

**

DAS
6
28
9-89

Location

Loc Qty

Loc Code

ST353

1

140880

1

D2563 Manufactured No

110 Each 0.0000 1 2

D2563

Step Weldment Assembly

**

DAS
6
28
9-89

B142121

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142284

D205-633-011

Required Date: 3/24/2016

Required Qty: 2.00

2

**

DAS

28

9-89

Loc Code

9.0000

DAS

~~28~~

9-89

Loc Code

6.0000

DAS

28

9-89

Loc Code

6.0000

DAS

28

9-89

Loc Code

6.0000

DAS

28

9-89

Loc Code

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Work Order ID: 142284

142284

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/21/2016

Required Date: 3/24/2016

Start Qty: 2.00

Required Qty: 2.00

D2565-111

Manufactured No

110 Each

8.0000

1 2

DAS
6
9-89

D2565-111

Strut

DAS
27
9-89

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST354

8

141051

8

2

MS21042L4

Purchased No

110 Each

2,007.000

8 16

DAS
6
9-89

MS21042L4

Locknut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

471

m133769

471

ST303

1402

m134055

1402

16

ST305

97

m130922

97

MS21042L5

Purchased No

110 Each

493.0000

2 4

MS21042L5

Nut

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST303

347

m134055

347

4

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DAS
27
9-89

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Work Order ID: 142284

142284

Parent Item: D205-633-011

D205-633-011

Parent Item Name: Heli-Access-Step™ - High Gear, Fits LH or RH

Start Date: 3/21/2016

Required Date: 3/24/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

110

Each

3,906.000

15 30

DAS

6
9-89

DAS

28
9-89

NAS1149D0463.J

WASHER

BAS
27
9-89

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

2681

M134039

2681

ST269

988

M132317

100

M132677

888

30

NAS1149D0563J

Purchased

No

110

Each

1,199.000

4 8

DAS

6
9-89

DAS

28
9-89

NAS1149D0563.J

Washer

BAS
27
9-89

Location

Loc Qty

Loc Code

GA

309

m125807

14

m133769

295

ST263

787

m133990

287

m134257

500

ST269

103

m128257

103

MAR 04 2016

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REFERENCE ONLY

DAS
27
9-89
IN-D205-633
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5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
(1)			1	D2021-101	EYEBOLT
(2)	2	2	2	D2022-101	SPACER
(2)	2	2	2	D2022-103	SPACER
(1)				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
(1)	(1)	1	1	D2563	WELDMENT ASSEMBLY
(1)				D2565-101	STRUT
(1)				D2565-103	STRUT
(1)				D2565-105	STRUT
(1)				D2565-107	STRUT
(1)				D2565-109	STRUT
(1)				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
(2)	1	1	2	AN4-5A	BOLT
(2)	3	3	2	AN4-6A	BOLT
(2)	2	2	2	AN4-7A	BOLT
(1)	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
(1)			1	AN5-6A	BOLT
(1)	1	1	1	AN5-14A	BOLT
(15)	16	16	15	AN960JD416	WASHER
(4)	3	3	4	AN960JD516	WASHER
(8)	8	8	8	MS21042L4	NUT (or MS21042-4)
(2)	2	2	2	MS21042L5	NUT (or MS21042-5)

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